

143

DART AEROSPACE LTD	Work Order:	21607
Description: Wearplate	Part Number:	D2577-7
Dwg: D2577 Rev. E	Qty:	Z1 Z0

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller: Dwg not required	KJ	04.09.29	20
2	PG	Issue P/O: <u>2006904</u> Email or Ship DXF file to vendor Laser Cut per Dwg D2577 flat pattern D2577-7 Material release note required		04.09.29	20
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CL	04/10/13	21
4	QC6	Inspect dimensions per template D2577-7T1	AB	04.10.2021	
5	GB	Deburr if necessary	Z	04.12.06	21
6	GB	Form on brake using DT8155 and DT8179 as per Dwg D2577 Identify as D2577-7	Z	04.12.06	21
7	GB	Form joggle as per Dwg D2577 using DT8157.	Z	04.12.06	21
8	QC5	Inspect work to Step 7	AB	04.12.2021	
9	FP	Powder Coat Grey (Ref.4.3.5.6) per QSI 005 4.3	MJ	05.03.17	21
10	QC3	Inspect Powder Coat	CD	05/03/17	21
11	FP	Identify and Stock	MJ	03.03.17	21
12	AC	Cost / part <u>14.30</u>	SAC	05-03-28	21
13	DC	Close W/O <u>13.84</u> Inspect Level 21	KJ	05.04.05	21

Rev	Date	Change	Revised By	Approved
A	96.08.20	New Issue		
B	98.10.15	Bending now in-house	KS	
C	99.02.02	Changed Powder Coat	DM	
D	00.04.10	Added ref. QSI 034	EC	
E	00.10.02	Rev.E dwg	EC	
F	02.09.24	Re-format	KJ RF	RF

RELEASED
02/10/02 RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 28, 2004
04:07 pm

Work Order No	:	0021607	Department Code:	
Project Name	:	D2577-7	Burden Flags	: NNNNNNNN
Project For	:	WK443	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2577-7	Invoice Number	:
Description	:	Wearplate	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	20	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	09-28-04	Est Margin	: 0.000%
Est Finish Date	:	10-21-04	Actual Margin	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00



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TEST CERTIFICATE

Ref: 322B/1122

CUSTOMER	Wilkinsted	SPECIFICATION	ASTM A106 CS Type A	CERTIFICATE No.	TCD 65404																			
CUSTOMER ORN	98-ZIN-226	PRODUCT	CRA WIRE COIL	PAGE	1 of 1																			
MILL ORN	35T24	DIMENSIONS	0.055" x 48" x CoB	DATE	08 April 2003																			
CHEMICAL COMPOSITION PERCENT																								
PACK NUMBER	HEAT No.	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ts	Al	B	N ₂	CE%	BEND	YIELD	T.S.	%ELONG	HARDNESS	LENGTH	
				x100					x1000						x10000	x100	180°		G.L.				(feet)	
R9-404632-00	622614	4	TR	17	12	16													Good				47	1539
R9-404633-00	622644	4	TR	17	12	16													Good				47	1512
R9-404634-00	622652	4	TR	20	12	14													Good				50	1588
R9-404635-00	622652	4	TR	20	12	14													Good				50	1568
R9-404636-00	622652	4	TR	20	12	14													Good				48	1506
R9-404637-00	622652	4	TR	20	12	14													Good				48	1499

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (γ)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
[A]=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=0 (C)=0.5 (D)=90 (F)=0"	(A)=10mm x 10mm (D)=2.5mm x 10mm (E)=7.5mm x 10mm (F)=5mm x 5mm	(A)=C+Mn/8 (B)=(C+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/8+Si/24 (D)=
[B]=LOWER YIELD STRESS	(B)=60mm (D)=6.85 ; So	(D)=(D ² /SD+2/45)/4		

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *British Misra*
OC METALLURGIST

16 ga crms

2003-04-08 14:53 PM 604 324 0075

WILKINSON STEEL

003

